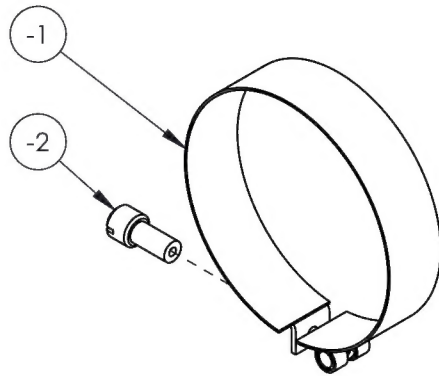


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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2	17-0048	UPDATED TO NEW DRAFTING STANDARD. <b>-1A, -1B, -1C, -2, -3, -4</b> CH'D TOLERANCE WAS .XXX ±.005, .XX ±.01, FRACTIONS ±1/32 IS .XXX ±.010, .XX ±.03, FRACTIONS ±1/64. <b>-1</b> ADDED WELDMENT AND DRAWING. <b>-1A</b> CH'D DIM WAS Ø.969 IS Ø2.969 ±.015/- .000. ADDED DIM (24 ga>) .03. <b>-1B</b> CH'D DIM WAS R1.509 IS R1.51, WAS (.063) IS (16 ga.) .06, WAS Ø.141 IS FULL R, ADDED DIM'S .63 ±.05, .72 ±.05, .40, R.06, (1.906), (.125). <b>-1C</b> CH'D DIM'S WAS .770 IS .77, WAS .050 IS .05, WAS .243 IS (.243), WAS .410 IS (.410), WAS .521 IS (.521), WAS .328 IS (.328), WAS 1.503 IS (1.503). ADDED DIM'S 2X R.03, FULL R, (1.750), R1.51, R.25, .48 ±.05, (.313), .51 ±.05, (24ga.) .025. <b>-2</b> CH'D DIM WAS 5-40 UNC $\nabla$ 9/16 IS 5-40 UNC -2B $\nabla$ 9/16. ADDED MED. KNURL NOTE. <b>-3</b> CH'D TO B/O PART MCMASTER-CARR #90575A151), DELETED DWG. <b>-4</b> CH'D DIM WAS 5-40 UNC THRU ALL IS 5-40 -2B UNC THRU ALL.	2/28/2017	RJC	JAG

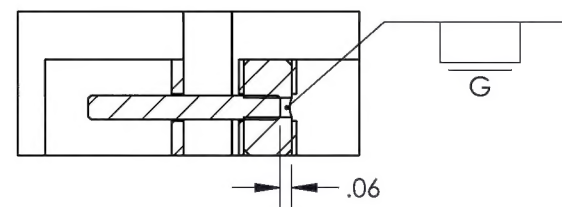
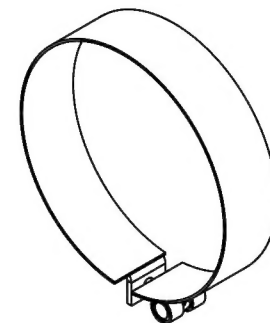
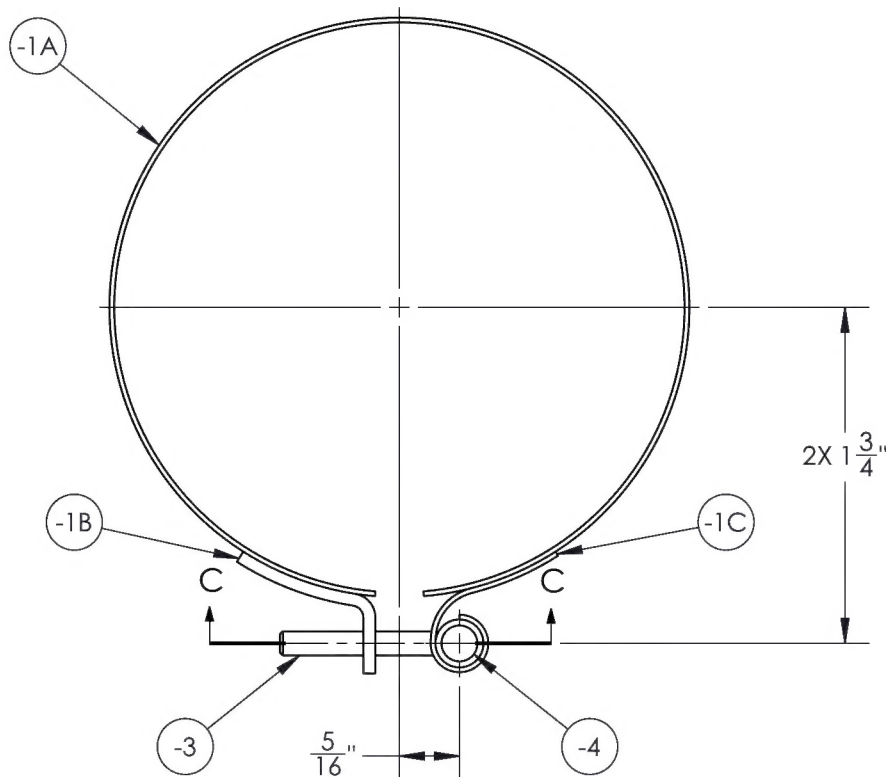


ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
	X		1	1	WELDMENT			2
	1		-1A		HOOP	AMS 5519E		3
	1		-1B		TAB	AMS 5518C		4
	1		-1C		TAB	AMS 5518C		5
			-2	1	KNOB	303		6
	1	B/O	-3		THREAD	S.S.	5-40 X 1 (MCMASTER-CARR #90575A151)	2
			-4		PIN	303		7
	ASSY -1							

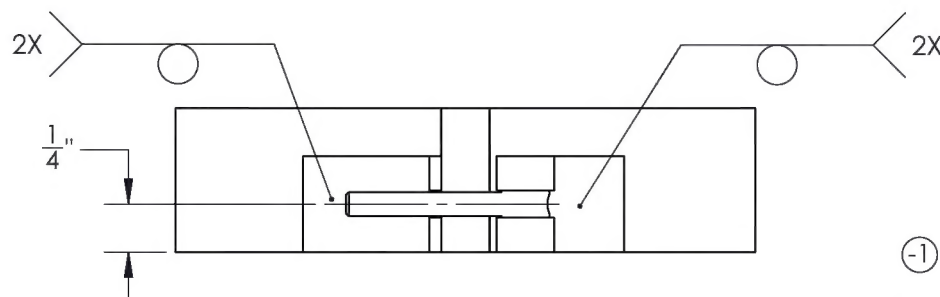
<b>DART</b> AEROSPACE		TITLE CLAMP-INSTALLATION, TURBINE OUTER COMBUSTION CHAMBER TO AIR DUCT(SEAL RING)	
		DWG NO. RB6799952	REV 2
MAT'L HEAT TREAT FINISH	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .010 FRACTIONS ± 1/64 .XX ± .03 ANGLES ± 1° .X ± .1 SURFACES = 125°		
SPEC	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R		
DRAWN BY:	GILBERT		
CHECKED:	DUERFELDT		
OPPS APPR:	ANDERSON		
QA APPR:	LINDSAY		
APPROVED:	GILBERT		
SCALE	1:2	DATE	9/11/2013
		SHEET 1 OF 7	

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2	17-0048	-1 ADDED WELDMENT AND DRAWING.	2/28/2017	RJC	JAG



SECTION C-C

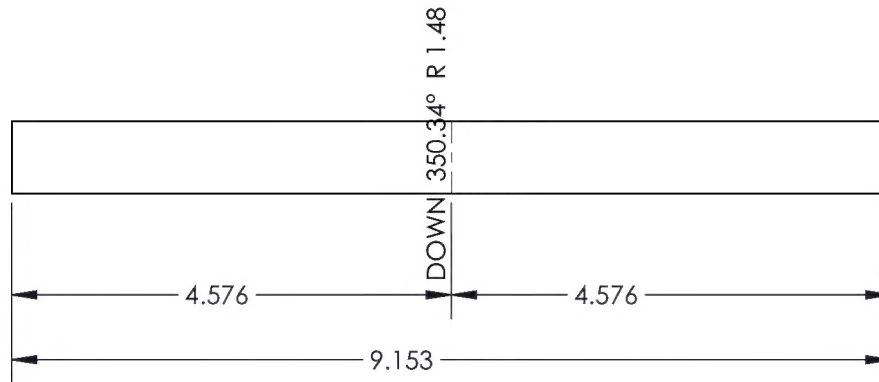
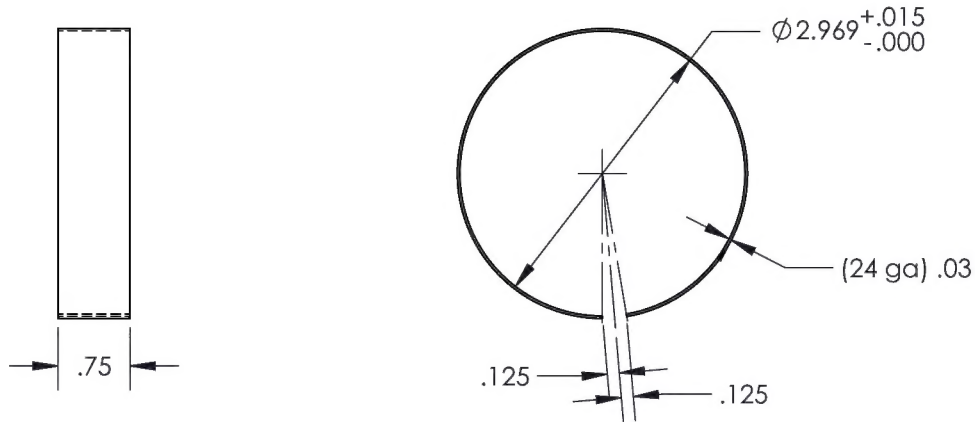


-1  
WELDMENT

<b>DART AEROSPACE</b>	
TITLE CLAMP-INSTALLATION, TURBINE OUTER COMBUSTION CHAMBER TO AIR DUCT(SEAL RING)	
DWG NO. RB6799952-1	REV 2
MAT'L	UNLESS OTHERWISE SPECIFIED
HEAT	DIMENSIONS ARE IN INCHES
TREAT	.XXX ± .010 FRACTIONS ± 1/64
FINISH	.XX ± .03 ANGLES ± 1°
SPEC	.X ± .1 SURFACES = 125°
DRAWN BY: GILBERT	1. BREAK ALL SHARP EDGES
CHECKED: DUERFELDT	.015 x 45° OR .015R
OPPS APPR: ANDERSON	2. DIMENSIONAL LIMITS APPLY
QA APPR: LINDSAY	AFTER PLATING
APPROVED: GILBERT	3. INTERPRET DIM AND TOL PER
	ASME Y14.5M-2009
	USED ON MODEL
SCALE 1:1	DATE 9/11/2013
	SHEET 2 OF 7

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REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
2	17-0048	-1A CH'D DIM WAS Ø0.969 IS Ø2.969 +.015/-0.000. ADDED DIM (24 ga>) .03. CH'D TOLERANCE WAS .XXX ±.005, .XX ±.01, FRACTIONS ±1/32 IS .XXX ±.010, .XX ±.03, FRACTIONS ±1/64.	2/28/2017	RJC
				JAG



FLAT PATTERN  
FOR REFERENCE ONLY

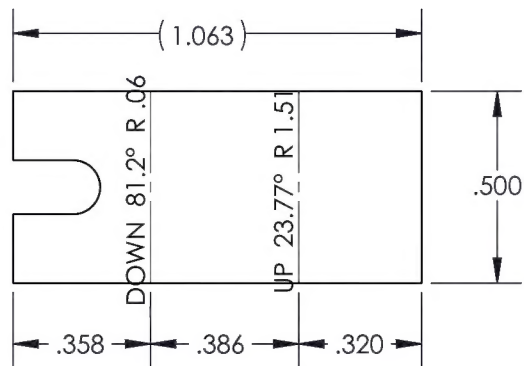
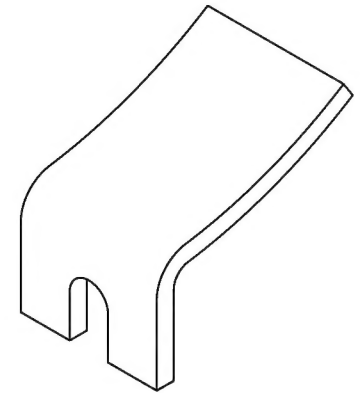
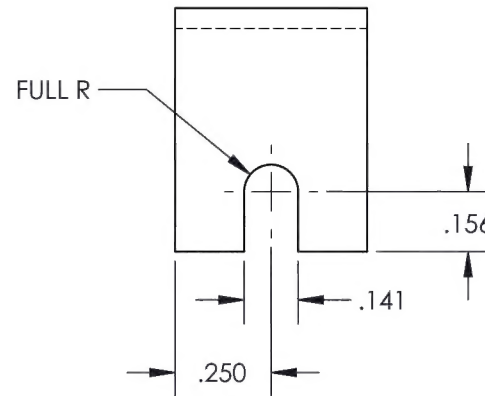
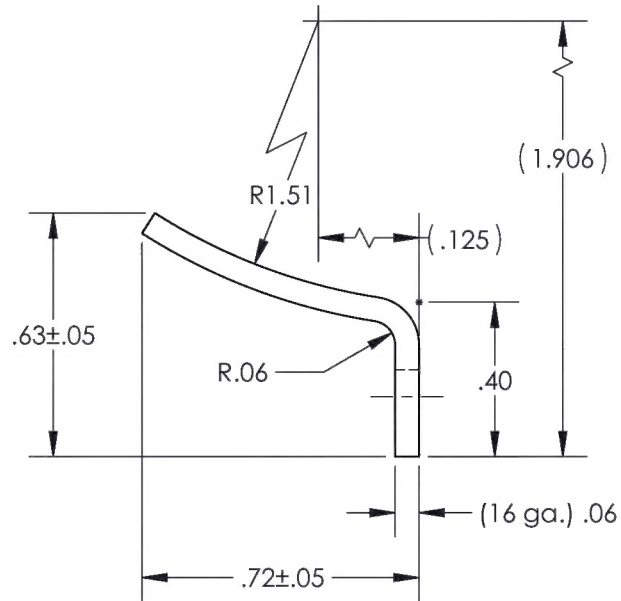
(-1A)

HOOP

<b>DART AEROSPACE</b>	
TITLE CLAMP-INSTALLATION, TURBINE OUTER COMBUSTION CHAMBER TO AIR DUCT(SEAL RING)	
DWG NO. RB6799952-1A	REV 2
MAT'L AMS 5519E	UNLESS OTHERWISE SPECIFIED
HEAT TREAT FINISH	DIMENSIONS ARE IN INCHES
SPEC	.XXX ± .010 FRACTIONS ± 1/64
DRAWN BY: GILBERT	.XX ± .03 ANGLES ± 1°
CHECKED: DUERFELDT	.X ± .1 SURFACES = 125
OPPS APPR: ANDERSON	1. BREAK ALL SHARP EDGES
QA APPR: LINDSAY	.015 x 45° OR .015R
APPROVED: GILBERT	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
SCALE 1:2	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
DATE 9/9/2013	USED ON MODEL
SHEET 3 OF 7	

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2	17-0048	-1B CH'D DIM WAS R1.509 IS R1.51, WAS (.063) IS (.16 ga.) .06, WAS Ø.141 IS FULL R. ADDED DIM'S .63 ±.05, .72 ±.05, .40, R.06, (1.906), (.125). CH'D TOLERANCE WAS .XXX ±.005, .XX ±.01, FRACTIONS ±1/32 IS .XXX ±.010, .XX ±.03, FRACTIONS ±1/64.	2/28/2017	RJC	JAG



FLAT PATTERN FOR REFERENCE ONLY

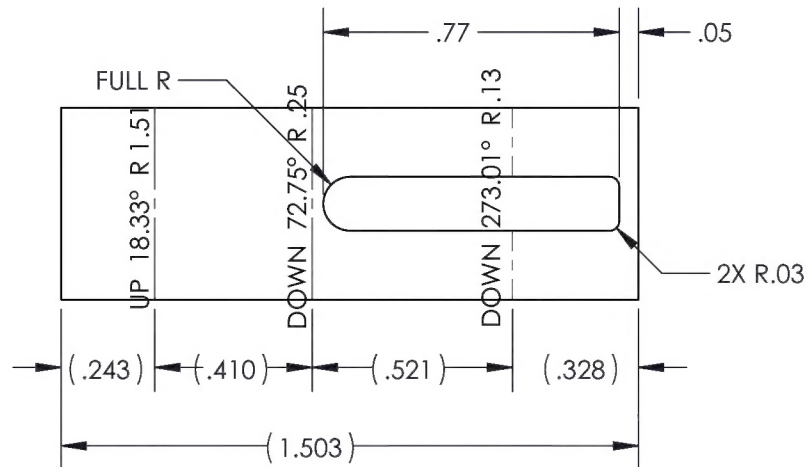
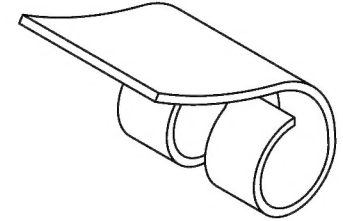
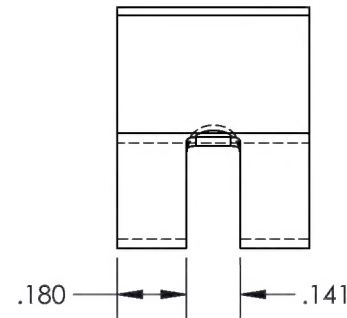
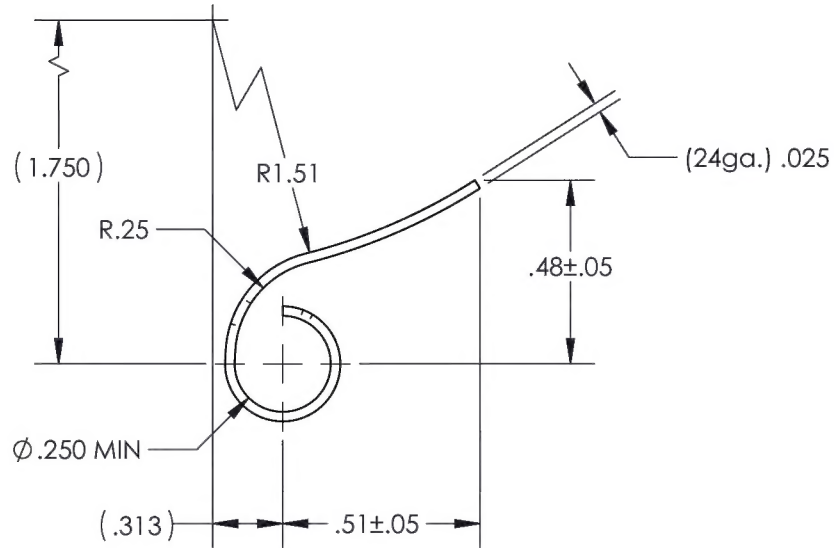
(-1B)

TAB

<b>DART AEROSPACE</b>	
TITLE CLAMP-INSTALLATION, TURBINE OUTER COMBUSTION CHAMBER TO AIR DUCT(SEAL RING)	
DWG NO. RB6799952-1B	REV 2
MAT'L AMS 5518C	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH	.XXX ± .010 FRACTIONS ± 1/64
SPEC	.XX ± .03 ANGLES ± 1°
	.X ± .1 SURFACES = 125°
DRAWN BY: GILBERT	1. BREAK ALL SHARP EDGES
CHECKED: DUERFELDT	.015 x 45° OR .015R
OPPS APPR: ANDERSON	2. DIMENSIONAL LIMITS APPLY
QA APPR: LINDSAY	AFTER PLATING
APPROVED: GILBERT	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
SCALE 2:1	DATE 9/6/2013
	SHEET 4 OF 7

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2	17-0048	-1C CH'D DIM'S WAS .770 IS .77, WAS .050 IS .05, WAS .243 IS (.243), WAS .410 IS (.410), WAS .521 IS (.521), WAS .328 IS (.328), WAS 1.503 IS (1.503). ADDED DIM'S 2X R.03, FULL R, (1.750), R1.51, R.25, .48 ±.05, (.313), .51 ±.05, (24ga.) .025. CH'D TOLERANCE WAS .XXX ±.005, .XX ±.01, FRACTIONS ±1/32 IS .XXX ±.010, .XX ±.03, FRACTIONS ±1/64.	2/28/2017	RJC	JAG



FLAT PATTERN

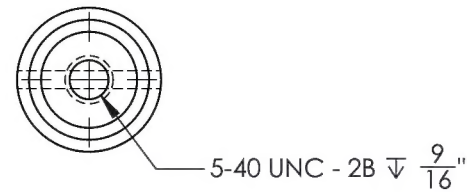
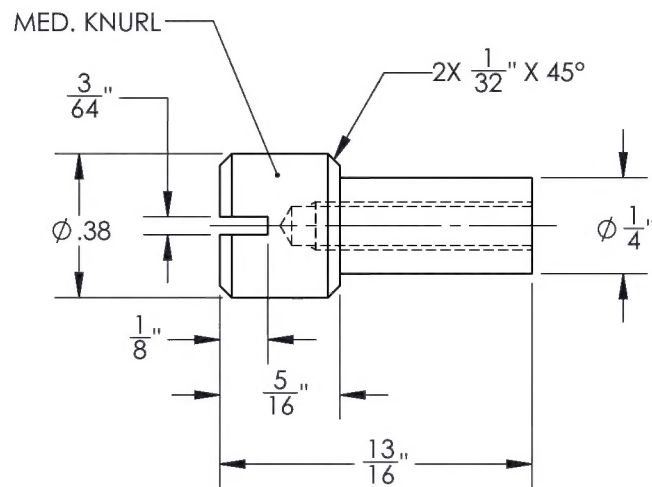
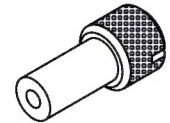
(-1C)

TAB

<b>DART AEROSPACE</b>	
TITLE CLAMP-INSTALLATION, TURBINE OUTER COMBUSTION CHAMBER TO AIR DUCT(SEAL RING)	
DWG NO. RB6799952-1C	REV 2
MAT'L AMS 5518C	UNLESS OTHERWISE SPECIFIED
HEAT TREAT FINISH	DIMENSIONS ARE IN INCHES
SPEC	.XXX ± .010 FRACTIONS ± 1/64
DRAWN BY: GILBERT	.XX ± .03 ANGLES ± 1°
CHECKED: DUERFELDT	.X ± .1 SURFACES = 125°
OPPS APPR: ANDERSON	1. BREAK ALL SHARP EDGES
QA APPR: LINDSAY	.015 x 45° OR .015R
APPROVED: GILBERT	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
SCALE 2:1	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
DATE 9/6/2013	USED ON MODEL
SHEET 5 OF 7	

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2	17-0048	-2 CH'D DIM WAS 5-40 UNC $\nabla$ 9/16 IS 5-40 UNC -2B $\nabla$ 9/16. ADDED MED. KNURL NOTE. CH'D TOLERANCE WAS .XXX $\pm$ .005, .XX $\pm$ .01, FRACTIONS $\pm$ 1/32 IS .XXX $\pm$ .010, .XX $\pm$ .03, FRACTIONS $\pm$ 1/64.	2/28/2017	RJC	JAG



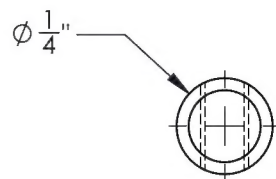
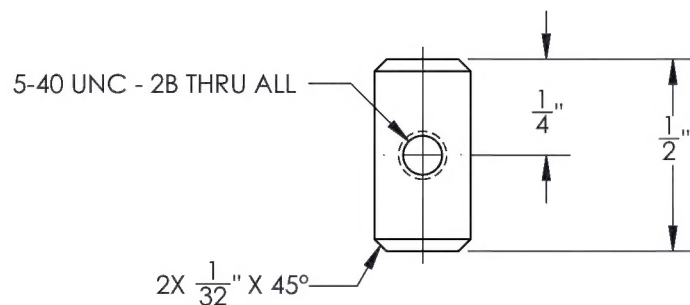
(-2)  
KNOB

<b>DART AEROSPACE</b>	
TITLE CLAMP-INSTALLATION, TURBINE OUTER COMBUSTION CHAMBER TO AIR DUCT(SEAL RING)	
DWG NO. RB6799952-2	REV 2
MAT'L 303	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TREAT	.XXX $\pm$ .010 FRACTIONS $\pm$ 1/64
FINISH	.XX $\pm$ .03 ANGLES $\pm$ 1°
SPEC	.X $\pm$ .1 SURFACES = 125
DRAWN BY: GILBERT	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: DUERFELDT	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: GILBERT	
SCALE 2:1	DATE 9/11/2013
SHEET 6 OF 7	



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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2	17-0048	-4 CH'D DIM WAS 5-40 UNC THRU ALL IS 5-40 -2B UNC THRU ALL. CH'D TOLERANCE WAS .XXX ±.005, .XX ±.01, FRACTIONS ±1/32 IS .XXX ±.010, .XX ±.03, FRACTIONS ±1/64.	2/28/2017	RJC	JAG



(-4)

PIN

<b>DART</b> AEROSPACE	
TITLE CLAMP-INSTALLATION, TURBINE OUTER COMBUSTION CHAMBER TO AIR DUCT(SEAL RING)	
DWG NO. RB6799952-4	REV 2
MAT'L 303	UNLESS OTHERWISE SPECIFIED
HEAT TREAT FINISH	DIMENSIONS ARE IN INCHES
SPEC	.XXX ± .010 FRACTIONS ± 1/64
DRAWN BY: GILBERT	.XX ± .03 ANGLES ± 1°
CHECKED: DUERFELDT	.X ± .1 SURFACES = 125
OPPS APPR: ANDERSON	1. BREAK ALL SHARP EDGES
QA APPR: LINDSAY	.015 x 45° OR .015R
APPROVED: GILBERT	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
SCALE 2:1	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
DATE 9/11/2013	USED ON MODEL
SHEET 7 OF 7	